

Work Order ID 65639-1

January 20, 2011 2:14:58 PM



Page 1

Item ID: D3041-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 1/20/11

Start Qty: 20.00



Cust Item ID:

Required Date: 2/18/11

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3041

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut D2423 Extrusion: 1.250" Long

cut @ meter

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Check for cracks while loading into the machine
Machine as per Folio FA153 and Dwg D3041
DWG REV: _____
FOLIO REV: _____

CX 1/10/21 (20)

issue P/O 13326

meter machine as per dwg D3041 REC

120

0.00



QC2-Inspect parts off machine FAI/FAIB

QC OK

Memo

0.00

Quality Control

rec'd + inspect for transit damage.

4/13/14 (8)

Work Order ID 65639

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Page 2

Item ID: D3041-3

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Process Plan:

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Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8 BR 11-3-7.

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Mask inside of 0.8120" diameter hole: START TIME: 2:05. OVEN TEMPERATURE: 220° FINISH TIME: 2:35.

8 BR 11-3-7.

Work Order ID 65639

January 20, 2011 2:14:59 PM



Page 3

Item ID: D3041-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 1/20/11

Start Qty: 20.00



Cust Item ID:

Required Date: 2/18/11

Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8. 6 11/03/07

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Press D2611 bearing into lug as per Dwg D3041 using DT 9472

2- Stake bearing into place as per Dwg D3041 using DT9456

3-Touch up stake marks with white emeron paint

EP 4/03/08

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/103/09

(18)

Work Order ID 65639

January 20, 2011 2:15:00 PM



Page 4

Item ID: D3041-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 1/20/11

Start Qty: 20.00



Cust Item ID:

Required Date: 2/18/11

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Picklist Print

January 20, 2011 2:14:58 PM

Page 1

Work Order ID: 65639

Parent Item: D3041-3

Parent Item Name: Clamp



Start Date: 1/20/11

Required Date: 2/18/11

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐ A ☐ 01.07.11 ☐ New Issue ☐ SM/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			170	f	534.1914	0.1042	2.193684			



CX 11/01/21

Location

Loc Qty

Loc Code

MAT06

534.1914265

43722

180

45800

66.1914265

63005

288

D2611



Bearing

Manufactured No

100 Each

20.0000



20

2.194
EB 11/03/08

Location

Loc Qty

Loc Code

ST020

20

51262

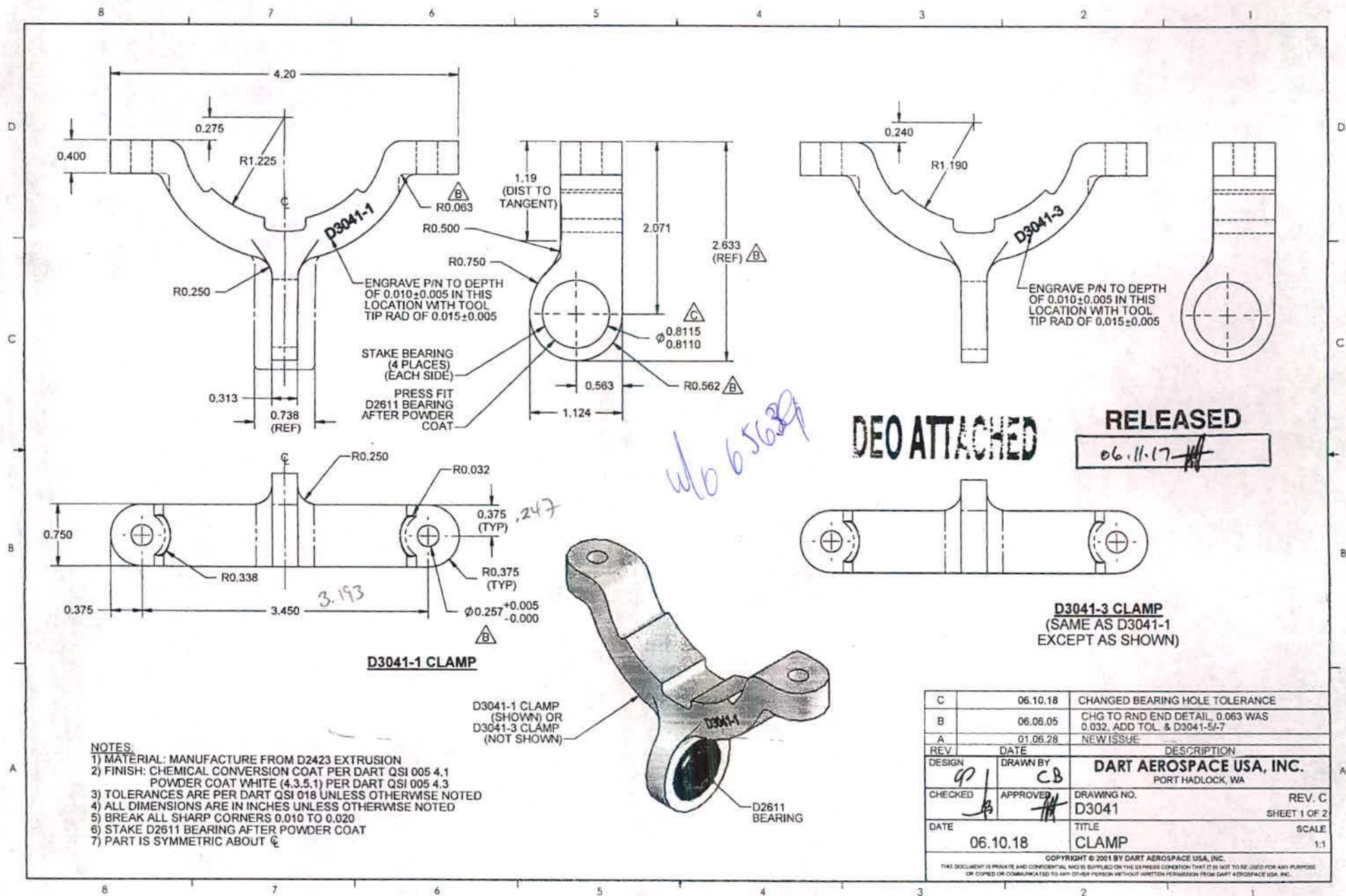
20

8

D 3041-3P

X20

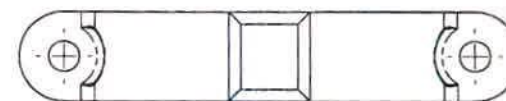
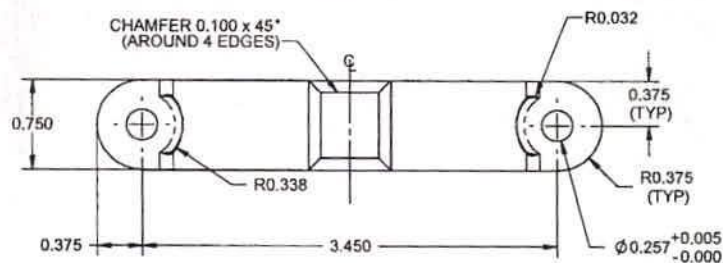
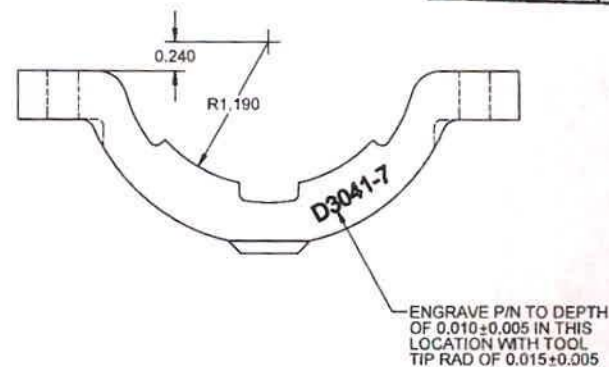
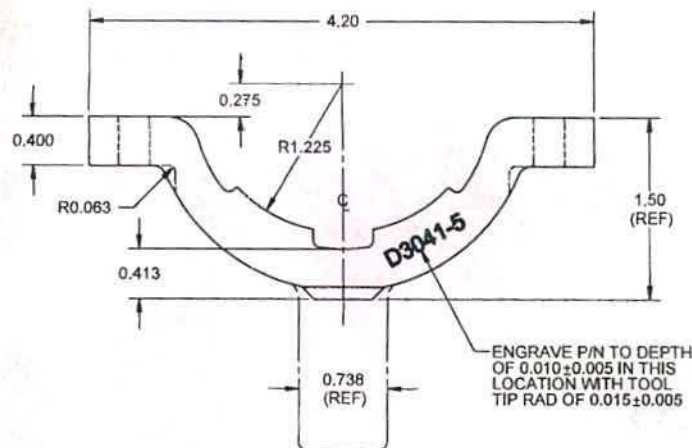
CX 11/03/07 X8



DEO ATTACHE

RELEASED

06.11.17

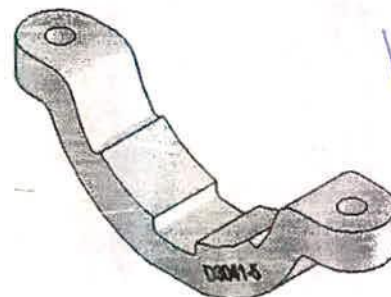


D3041-5 CLAMP

D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT ϕ

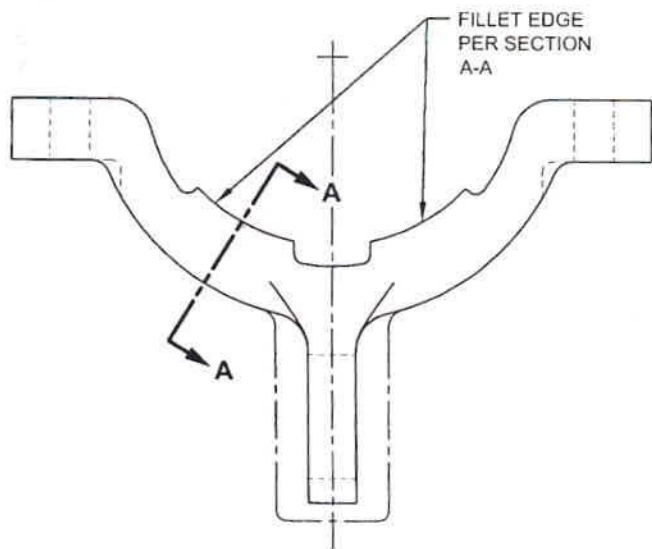


DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
qf	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
B	H	D3041	SHEET 2 OF 2
DATE	TITLE	SCALE	
06.10.18	CLAMP	1:1	

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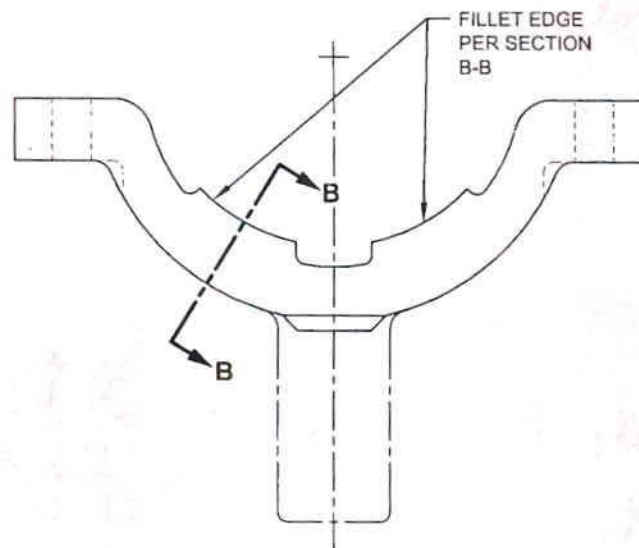
DRAWING NO. D3041	TITLE CLAMP	REV: C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13	DATE 09.03.13	

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



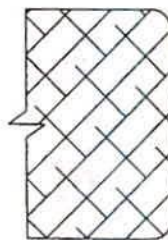
D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

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DART AEROSPACE LTD		Work Order: 65639
Description: Clamp		Part Number: D3041-3
Inspection Dwg: D3041	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	+/-0.030					
0.240	+/-0.010					
R1.190	+/-0.010					
0.400	+/-0.010					
R0.250	+/-0.010					
0.313	+/-0.010					
R0.063	+/-0.010					
1.19	+/-0.030					
1.124	+/-0.010					
0.563	+/-0.010					
R0.562	+/-0.010					
Ø0.8115 - 0.8110	N/A					
2.071	+/-0.010					
0.750	+/-0.010					
0.375	+/-0.010					
R0.338	+/-0.010					
3.450	+/-0.010					
Ø0.257	+0.005-0.000					
R0.375	+/-0.010					
0.375	+/-0.010					
R0.032	+/-0.010					
R0.250	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577

OUTSTANDING PO REPRINT

Purchase Order ID PO13326

Purchase Order Date 1/20/2011

PO Print Date 2/15/2011

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Unit Price	Extended Price
----------	--	------------------------	----------------------	---------	------------	----------------

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REFERENCE ONLY

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
4	D3041-1P	Clamp	1/28/2011 Yes	20.00 Each	Yours ppd	\$31.0000	\$620.00

Special Inst: MACHINE AS PER DWG D3041 REV.
C
B65638

Line Total: \$620.00

5	D3041-3P	CLAMP	1/28/2011 Yes	20.00 Each	Yours ppd	\$31.0000	\$620.00
---	----------	-------	------------------	---------------	-----------	-----------	----------

Special Inst: MACHINE AS PER DWG D3041 REV.
C
B65639

Line Total: \$620.00

REFERENCE ONLY

1/21/2011



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17801
Date: Mar 04, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13326	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-3 Crosstube Lug Material supplied by DART: D2423 B45800	Each	30		
D3910-1 Crosstube Lug Material supplied by DART: D2423 B	Each	30		
D4091-1 Lug Material supplied by DART: D2423 B	Each	24		
D3041-1 Clamp Material supplied by DART: D2423 B	Each	20		20
D3041-3 Clamp Material supplied by DART: D2423 B	Each	20	5	15
Received by _____				
Thank you for your order!				

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

5820

D3041-3

Clamp


13326

MATERIAL: supplied by DART D2423 B63005

8.11.08/07

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, March 4, 2011